

Date: Monday, 2/19/2007 8:08:01 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPAD
Job Number : 30757	
Estimate Number : 12712	
P.O. Number : N/A	Part Number : D35371 Rev 4 014
This Issue : 2/19/2007 S.O. No. : N/A	Drawing Number : D3537 UNDER REVIEW 07.02.19
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : U/R
Previous Run : N/A	Material : N/A
Written By : _____	Due Date : 2/26/2007 Qty: 72 Um: Each
Checked & Approved By : <u>07.02.19</u>	
Comment : Est Rev: A New Issue: 07-02-14 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.0788 sf(s)/Unit Total : 5.6700 sf(s)
 M304S16GA .063" 304 SS SHEET 6.0640
 Batch: M101873

ml

07/03/07

72

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3537
 Dwg Rev: A
 Prog Rev: A

ml

07/03/08

(72)

07/03/09

(72)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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ml 07.03.08

(72)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07/03/08 (72)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.
 2-Identify as D3537-1

JB 07/03/14 (72)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3537-1 PAR #: N/A Fault Category: Roll/Maximal PARTS NCR: (Yes) No DQA: 20 Date: 07/03/20
 QA: N/C Closed: 10 Date: 07.03.20

NCR: <u>30757</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		6 scrap, program was wrong.	<u>Q51042</u>	Scrap + Replace	<u>ml</u> <u>07 03 08</u>	<u>0703-08</u>	<u>Q51042</u>	<u>0703-08</u>
<u>0703 08</u>	<u>2.0</u>	5 were scrap 3 due to program adjustment, and 2 operator error	<u>Q51042</u>	scrap + Replace	<u>ml</u> <u>07 03 08</u>	<u>07/03/08</u>	<u>Q51042</u>	<u>07/03/08</u>

NOTE: Date & initial all entries

Date: Monday, 2/19/2007 8:08:01 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 30757

Part Number: D35371

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

1-5600 Hardcoat

M102755

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

FC 07/03/19 (72)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/03/19

(72)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/19

(72)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M.R.

07/03/19

(72)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/13/19 (72)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 575

07/13/19 (72)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/20

(72)

Job Completion



U 07-03-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

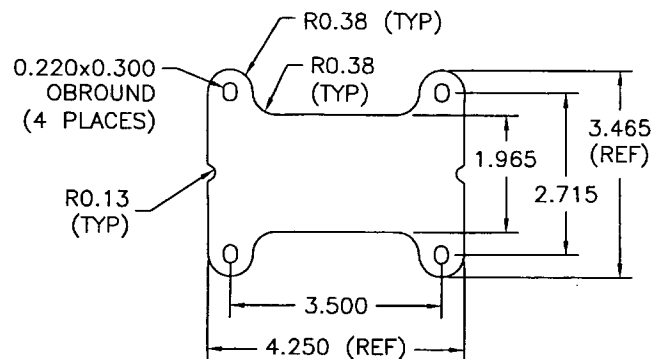
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

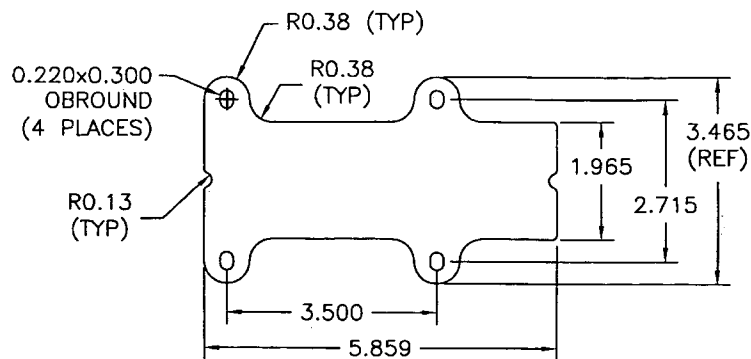
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

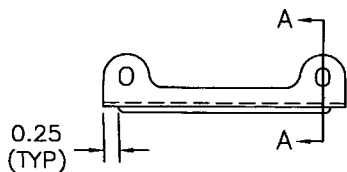
D3537-1F FLAT PATTERN



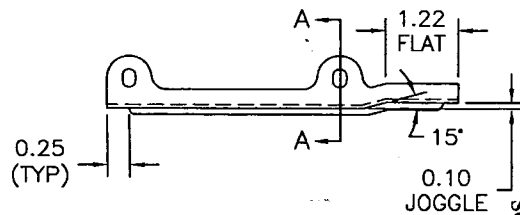
D3537-3F FLAT PATTERN



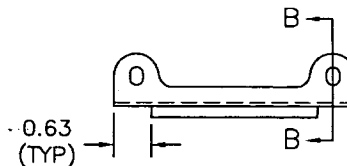
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



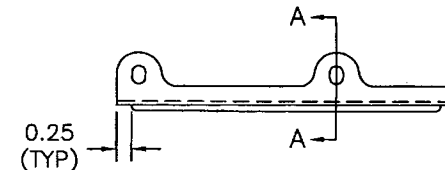
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



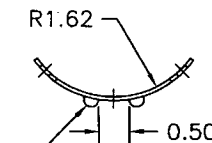
D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)

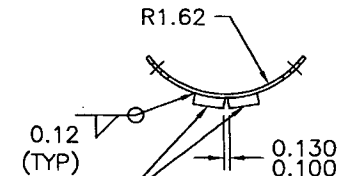


SECTION A-A



2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.063 TO 0.125 THICK

SECTION B-B



D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

RELEASED

07-02-12

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 16 GAUGE
(0.063 THICK, REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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NO 30757

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A	06.11.06	NEW ISSUE
DESIGN CB	DRAWN BY CB	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED PH	APPROVED H	DRAWING NO. D3537
DATE 06.11.06	TITLE WEARPAD	REV. A SHEET 1 OF 1 SCALE 1:2

